

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004838**Date Inspected:** 26-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Makhmud Ashadi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM) Quality Assurance Inspector (QA) James Weaver was present at the Japan Steel Works (JSW) jobsite in Muroran, Japan for the purpose of observing in-process fabrication of components for the Tower, Jacking and Deviation Saddles. Current work: Casting, machining, welding and nondestructive testing of Saddles and Bases.

T1-2 Base

The QA inspector observed the in process welding of the structural steel plates for the Tower Saddle Base T1-2. The JSW welding personnel S. Watanabe, ID 08-5159 and K. Yashihito, ID 08-5158 were welding weld joint terminations in the horizontal position. Intertek Testing Services Quality Control (QC) inspector Mr. Makhmud Ashadi monitored the welding parameters and heat control at periodic intervals. The minimum preheat temperature of 110°Celsius and maximum interpass temperature of 260°Celsius were verified to meet the WPS requirements by Mr. Ashadi and the QA inspector utilizing Tempilstik temperature indicators. This data was entered into the QC inspector's daily log, identifying the location on a weld map. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.

Summary of Conversations:

There were general conversations with Intertek Testing Services Certified Welding Inspector Mr. Makhmud Ashadi relative to the location of the welding and inspection personnel in the fabrication shop number 4.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Weaver,James	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
